

FIG. 1

Table 1

Ex. No. Components	Comp.	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18
	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%
Rosin (KE604) *	40	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35
TPNB *	54	54	54	54	54	54	54	54	54	54	54	54	54	54	54	58	39	58	39
Styrene dibromide	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
Thixatrol + <sup>c</sup>	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4
Isocarb 24 <sup>d</sup>		5												2.5	4	1	20		
Isocarb 36 *			5																
Isocarb ester 1605 <sup>f</sup>			5											2.5	1		1	20	
Kristol T60 *				5															
Paracera MW <sup>h</sup>					5														
Iso stearic acid						5													
Stearic acid							5												
Palmitic acid								5											
Micronised PTPE <sup>i</sup>										5									
200/100cS <sup>j</sup>											5								
Dow Corning 704 *												5							
Isolol 24 <sup>k</sup>													5						

\* Rosin (KE604) available from Arakawa is an acid modified hydrogenated rosin. <sup>b</sup> TPNB available from DOW is tri(propylene glycol) butyl ether.

<sup>c</sup> Thixatrol + available from Rheox is a rheological additive. <sup>d</sup> Isocarb 24 available from Condea is 2-decyltetradecanoic acid.

<sup>e</sup> Isocarb 36 available from Condea is 2-hexadecyltetraol.

<sup>f</sup> Isocarb ester 1605 available from Condea is 2-hexyldecanoic acid-pentaerythritol ester.

<sup>g</sup> Kristol T60 available from Carless is mineral oil. <sup>h</sup> Paracera MW available from Industrial Waxes Ltd is paraffin wax.

<sup>i</sup> Micronised PTPE available from Rant Ltd is PTFE micropowder. <sup>j</sup> 200/100cS available from Dow Corning is polydimethylsiloxane.

<sup>k</sup> Dow Corning 704 available from Dow Corning is Tetramethyltetra-phenyltrisiloxane and pentaphenyltri-methyltrisiloxane.

<sup>l</sup> Isolol 24 available from Condea is 2-decyltetradecanol.

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FIG. 2

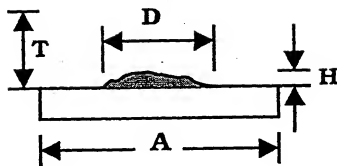


FIG. 3

Table 2

SCORE	DESCRIPTION	VALUES
1	No paste or almost no paste	$D < \frac{1}{2}A$ $H < \frac{2}{3}T$
2	More than $\frac{1}{2}$ of pad area covered but insufficient height	$D < \frac{1}{2}A$ $H < \frac{2}{3}T$
3	More than $\frac{2}{3}$ pad area covered, paste reaches same height as stencil	$D < \frac{3}{4}A$ $H = T$ for $< \frac{1}{2}A$
4	More than $\frac{2}{3}$ pad area covered and diameter of top is $> \frac{1}{2}$ of aperture	$D < \frac{3}{4}A$ $H = T$ for $< \frac{1}{2}A$
5	Perfect deposit, same shape as stencil aperture	$D = A$ $H = T$ for $> \frac{3}{4}A$

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FIG. 4

TABLE 3

Example	Additive (%)	Score
Comparative	None	2
1	Isocarb 24	3
2	Isocarb 36	5
3	Isocarb ester 1605	4
4	Kristol T60	4
5	Pancera MW	4
6	Iso stearic acid	4
7	Stearic acid	3
8	Palmitic acid	4
9	Micronised PTFE	3
10	200/100cS	3
11	Dow Corning 704	3
12	Isfol 24	4
13	Isocarb 24 (2.5) / Isocarb ester 1605 (2.5)	4
14	Isocarb 24 (4) / Isocarb ester 1605 (1)	3
15	Isocarb 24 (1)	3
16	Isocarb 24 (20)	4
17	Isocarb ester 1605 (1)	3
18	Isocarb ester 1605 (20)	3

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